



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2360
Job Sheet 211680



Part No: D2360

Job Qty: 6 pcs

Part Name: Litter Tie Down Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/20

Job Tracking No:

Due Date: 8/31/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2341 REV G, D2360 REV D IPP rev H 07.06.12 ecn 825 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	6 pcs		8/28/20	0.00	0.20	Bandsaw - 1			ALA 20/08/20
110	HAAS 4 Axis - B4B	6 pcs		8/29/20	0.26	8.96	HAAS - 1 - B4B			ALA 20/08/20
							HAAS - 2 - B4B			
							HAAS - 3 - B4B			
							HAAS - 4 - B4B			
120	QC 2	6 pcs		8/29/20	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			



Container No: S291460

Part: D2360
Job No: 211680
Serial No/Batch: S291460
Revision: 
Inspector: 
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/01/20



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Container No: S291460



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Revision: G

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Exp Date:

Instructions: Various STC's

Date: 08/01/20

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130	QC 8	6 pcs	8/29/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
140	Handfinish - 1-1 Chemical-B4B	6 pcs	8/29/20	0.00 0.47	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B

mk 20/08/02

150 Powdercoat - 1 White GI(A)- B4B	6 pcs	8/29/20	0.00 0.30	Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
160 QC 3	6 pcs	8/29/20	0.00 0.00	Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
170 Small Fab - 2 - B4B	6 pcs	8/31/20	0.00 1.89	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
180 QC 5	6 pcs	8/31/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	

2020/08/06

20-08-12

8-89

DAS
58 AUG 14 2020
9-89DAS
58 9-89
DAS
58 9-89

					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	DAS
					QC 5 - 50	31
					QC 5 - 30	9-89
					QC 5 - 40	AUG 14 2020
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
190	Packaging 3-1 - Stock - B4B	6 pcs	8/31/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	AUG 17 2020
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	DAS
200	QC 21 - SA	6 pcs	8/31/20	0.00 0.00	QC 21 - SA - 21	21
					QC 21 - SA - 70	9-89
					QC 21 - SA - 9	AUG 17 2020
					QC 21 - SA - 77	

Part Op 100 - (Bandsaw) Cut blanks: 12.65" Long
 Descriptions: 110 - (HAAS CNC vertical machine #1) 1-Machine as per Folio D2341 and Dwg D2341 2-Deburr

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 11:45 MDSH-109 OVEN TEMPERATURE:

520° FINISH TIME: 12:15

- 160 - (QC3- Inspect Part Finish)
 170 - (Small Fab) Assemble as per dwg D2360
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Identify as per dwg & Stock Location: _____)
 200 - (QC21- Final Inspection - Work Order Release)

016879

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	6.3240 ft (1.054 ea)	100-Bandsaw - 1	S229069
AN526C1032R18	Screw	10 8 Ea (1 ea)	170-Small Fab - 2 - B4B	F4523
D2002-015	Knob	20 12 pcs (2 ea)	170-Small Fab - 2 - B4B	S230630
D2345	Lock Channel	10 6 pcs (1 ea)	170-Small Fab - 2 - B4B	S229120
D2366	Lock Handle	20 12 pcs (2 ea)	170-Small Fab - 2 - B4B	(11x) S229110 (9x) S291902
D2367	Handle Knob	10 8 pcs (1 ea)	170-Small Fab - 2 - B4B	S198547
D2372	Quick Release	20 12 pcs (2 ea)	170-Small Fab - 2 - B4B	(7x) S246278
D2373	Spring	12 6 pcs (1 ea)	170-Small Fab - 2 - B4B	S271353
D2444	Pip Pin Assembly	12 6 pcs (1 ea)	170-Small Fab - 2 - B4B	S293133
MS20470AD3-4	Rivet, Universal Head	12 6 Ea (1 ea)	170-Small Fab - 2 - B4B	Fm13665-40
MS21042L3	Nut	30 16 Ea (3 ea)	170-Small Fab - 2 - B4B	S289457
MS27039-1-13	Screw	10 8 Ea (1 ea)	170-Small Fab - 2 - B4B	S006972
MS27039-1-15	Screw	20 12 Ea (2 ea)	170-Small Fab - 2 - B4B	S237872
NAS1149D0332J	Washer	80 46 Ea (8 ea)	170-Small Fab - 2 - B4B	S293661
NAS1149D0363J	Washer	20 12 Ea (2 ea)	170-Small Fab - 2 - B4B	S285157
NAS679A3W	Nut	10 8 Ea (1 ea)	170-Small Fab - 2 - B4B	S228640

1/10

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D6201	6	19	0
170-Small Fab - 2 - B4B	AN526C1032R18	6	17	0
	D2002-015	12	23	0
	D2345	6	20	0
	D2366	12	11	0
	D2367	6	22	0
	D2372	12	7	0
	D2373	6	24	0
	D2444	6	7	0
	MS20470AD3-4	6	4,359	0
	MS21042L3	18	1,091	0
	MS27039-1-13	6	165	0
	MS27039-1-15	12	137	0
	NAS1149D0332J	48	846	0
	NAS1149D0363J	12	1,118	0
	NAS679A3W	6	189	0

Part Specifications

Specifications could not be found.

Plex 7/24/20 7:38 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					